

Date: Monday, 6/12/2006 3:29:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACEPOD BODY RH		
Job Number	: 27494A		Part Number	: D31882		
Estimate Number	: 11102		Drawing Number	: D3188 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/12/2006 S.O. No. : N/A		Drawing Revision	: A		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/15/2006 Qty: 1 Um: Each		
Previous Run	: 27493A					
Written By	: <i>[Signature]</i>					
Checked & Approved By	: <i>[Signature]</i> 06 06 13					
Comment	: Est Rev A New Issue 05-11-29 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2213	Aluminum Spacer 	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Ship To Delastek			
8	D2213	Spacer	Batch: B22997A C20615/06 ⑧
2.0	PG	PURCHASING 	
Comment: PURCHASING Issue P/O: 1494 C20615/06 ① Description: D3188-2 BODY SHIP LABEL D0600-142 & D2213 Spacers Supplier: Delastek Conformity Certificate and Process sheet required Ship 2 Items from Previous steps			
3.0	D31882P	Spacepod Body 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Spacepod Body			
4.0	PACKAGING 1	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: DJDate: 06/16/20

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 6/12/2006 3:29:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 27494A

Part Number: D31882

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188. Visual inspection. Check for void spot and pins.

MD 06/10/18

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *NA*

7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/10/20

Job Completion



06.10.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN JB	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3188	REV. A SHEET 1 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	

RELEASED

03.04.03

04 COPY ISSUED

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
 12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 18 oz ROVING "E" GLASS (18 oz CLOTH)
 OWENS CORNING MILLED FIBERS, "E" GLASS
 3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
 OR DIVINYCELL
 OR AIREX
 OR KLEGECCELL
 FILL Voids IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SCHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1	DT8003	DT8501
D3188-2	DT8004	DT8502
D3188-3	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

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WORK ORDER

NO. *274921A*

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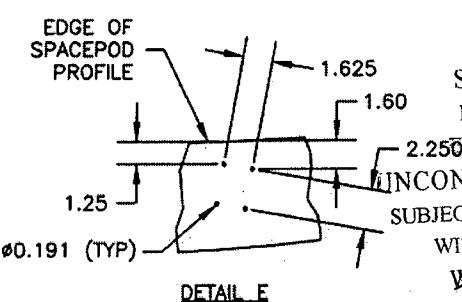
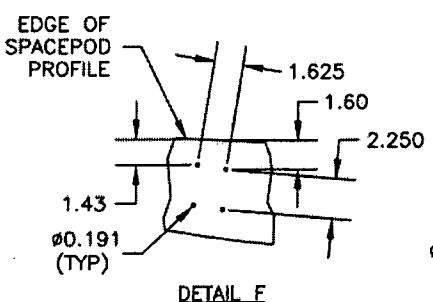
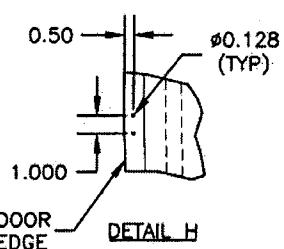
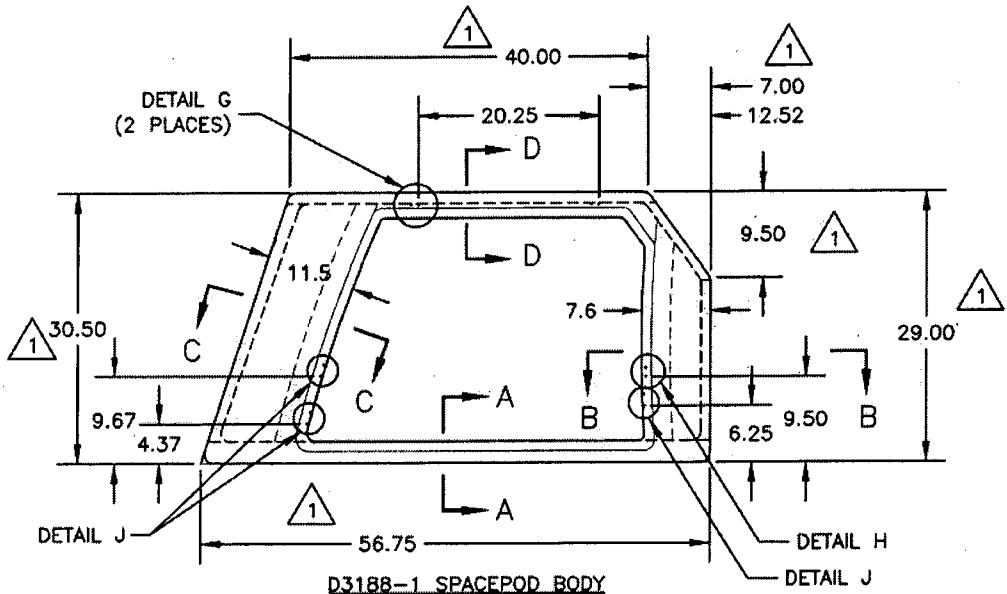
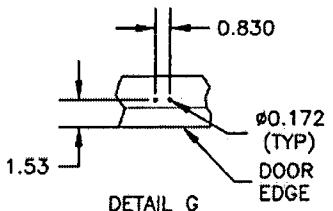
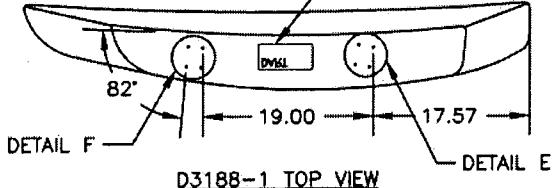


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DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

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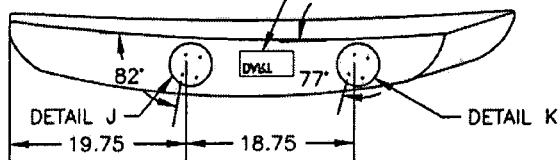
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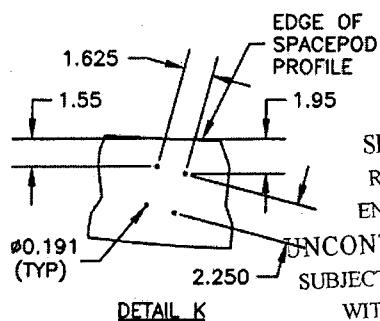
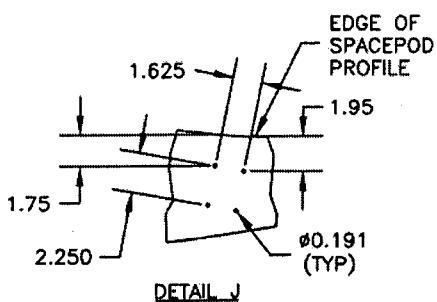
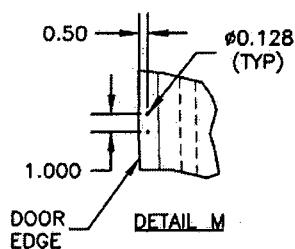
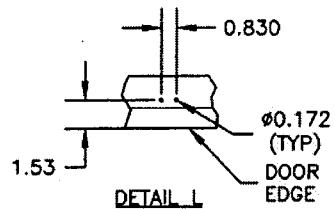
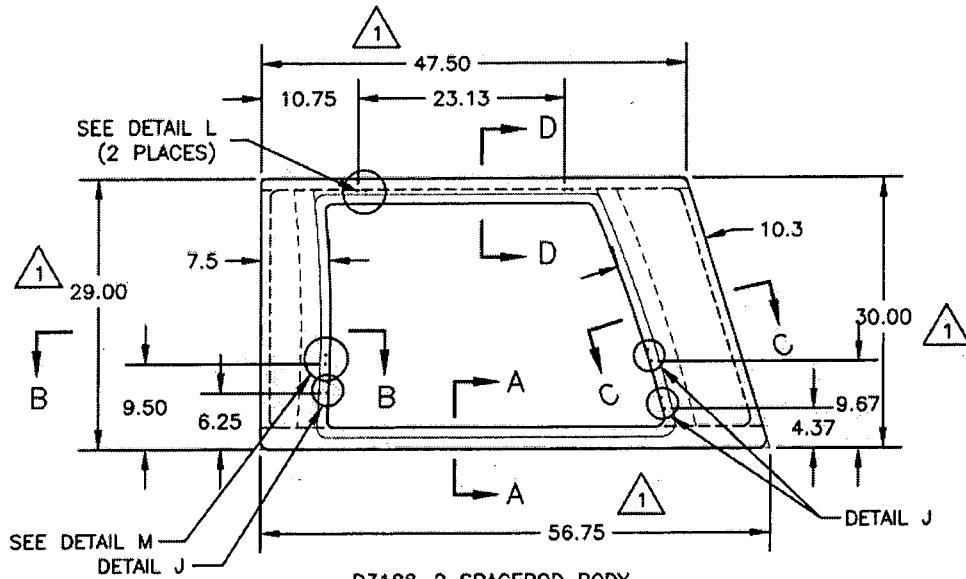
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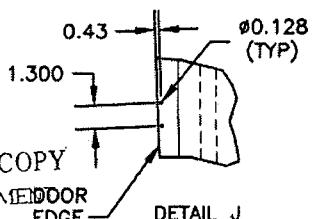
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DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

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D3188-2 TOP VIEW



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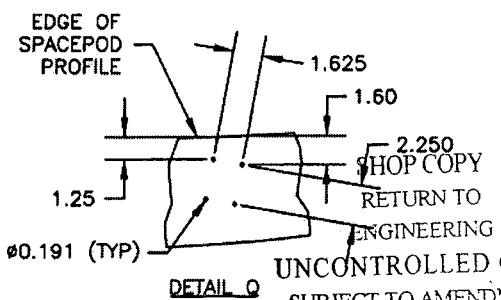
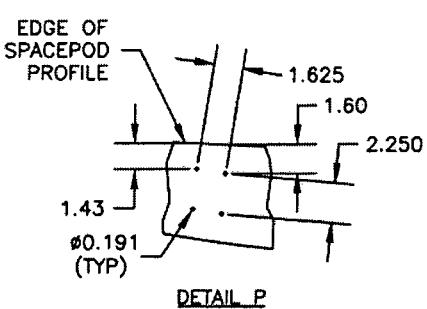
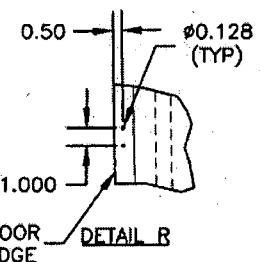
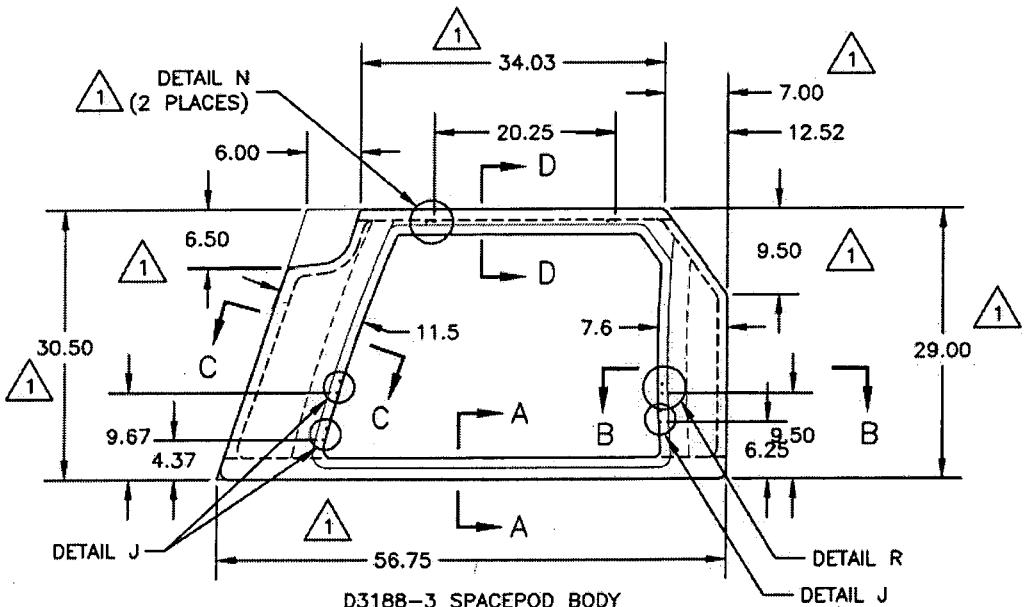
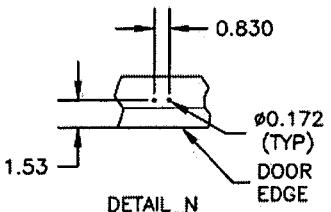
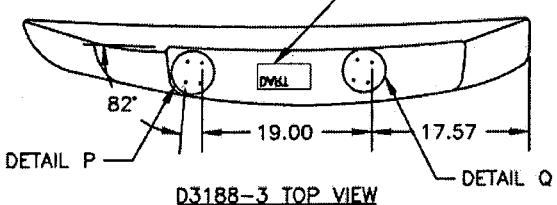


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DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

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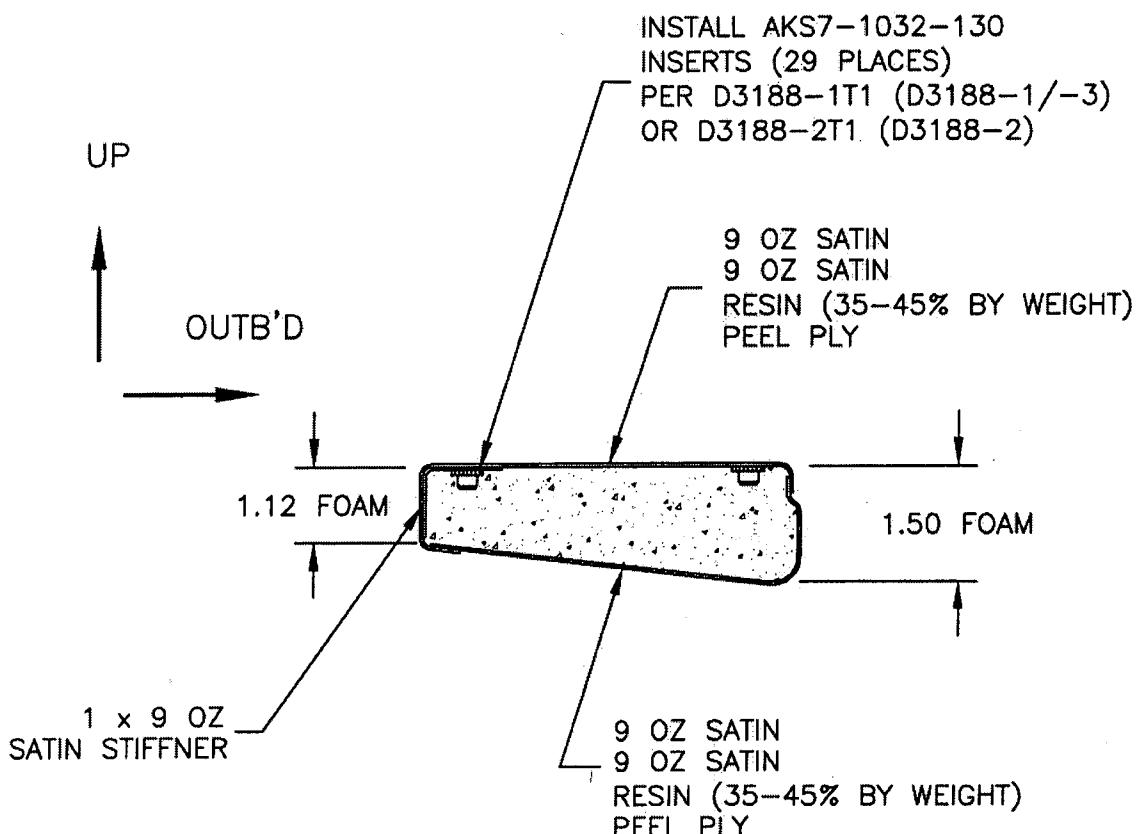
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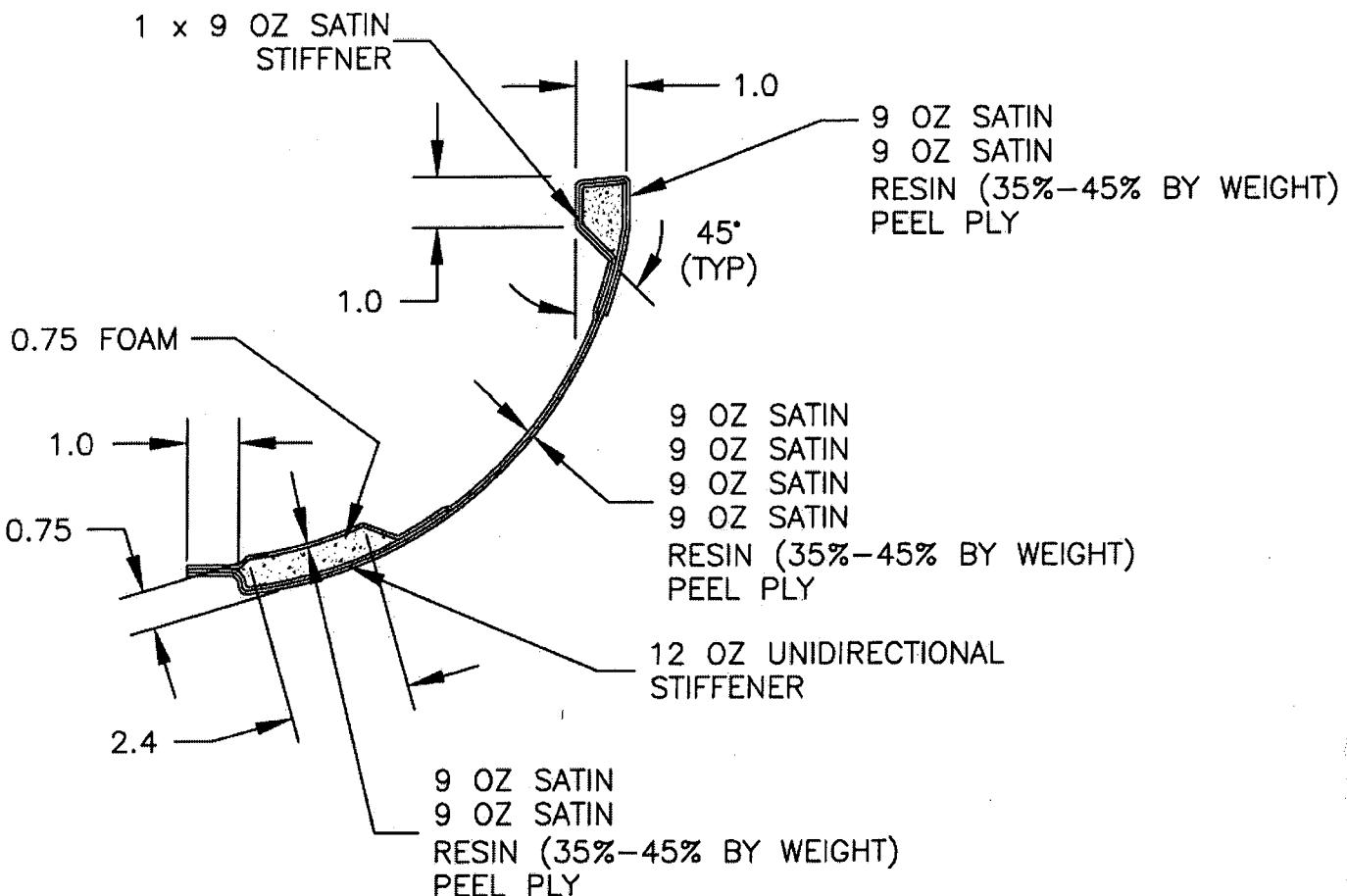
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DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

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SECTION B-B
(SECTION C-C SIMILAR)

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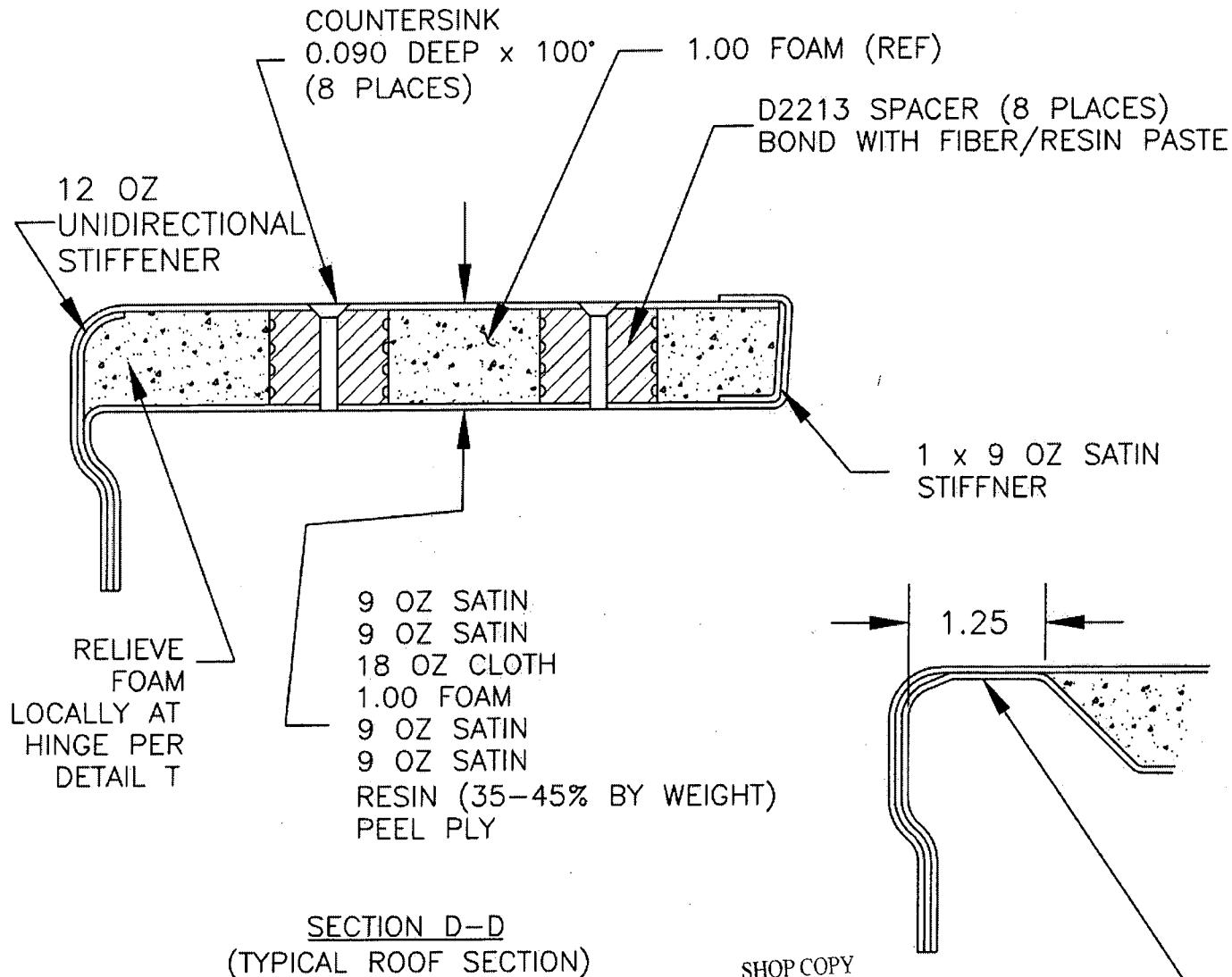
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